

DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2**
REF: CANADIAN STC: SH01-5
REF: FAA STC: SR01304NY

For D206-667-101/-201/-103/-203 or D407-667-105 cross tubes at CHG 003 or later , the D2856-400-694/-773 abrasion strip has been removed, the center D2891-1 or D2892-1 support has been bonded onto the crosstube using Magnabond 6398 and D3595-075-395/-450 Rubber Cushions have been installed underneath the MS21920-20/-22 Clamps. Amend parts list of the IIN-D206-667 section 5 and ICA-D206-667 Section 32.8 as follows:

REMOVE:

| ITEM | QTY -101 | QTY -201 | QTY -103 | QTY -203 | QTY -105 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-------------|---------------|----------------|
| 13 | 2 | 2 | 2 | | 2 | D2856-400-694 | ABRASION STRIP |
| 14 | | | | 2 | | D2856-400-773 | ABRASION STRIP |

ADD:

| ITEM | QTY -101 | QTY -201 | QTY -103 | QTY -203 | QTY -105 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-------------|---------------|----------------|
| 24 | 4 | 4 | 4 | | 4 | D3595-075-395 | RUBBER CUSHION |
| 25 | | | | 4 | | D3595-075-450 | RUBBER CUSHION |

To prevent the supports from shifting on the D206-667-101/-201/-103/-203 or D407-667-105 crosstubes at CHG 002 or earlier, the D2891-1/D2892-1 supports should be removed and re-installed as follows:

- Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- Remove the qty (2) MS21920-20/-22 clamps from the crosstube that fasten the D2891-1/D2892-1 supports to the crosstube.
- Remove the D2856-400-694/-773 abrasion strip from the crosstube per section 32.5 of ICA-D206-667.
- Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D206-667. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D206-667. Touch up finish per item 5.3.9 of the 300 hour inspection.
- Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath the D2891-1/D2892-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1/D2892-1 support on the crosstube using MS21920-20/-22 Clamps. Install a D3595-075-395/-450 Rubber cushion underneath each MS21920-20/-22 Clamp. Torque clamps 80-100 in-lb. Let the D206-667-101/-201/-103/-203 or D412-667-105 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 08.05.26
CERT. NO.: SH01-5
ISSUE NO.: 3

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|------------|--------------------|--|--------------|
| A | NEW ISSUE | HS | 08.05.26 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | HS | | |
| CHECKED | <i>PH</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | DSI 9415 | SHEET 1 OF 2 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | CROSSTUBE SUPPORT CHANGE | NTS |
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7) Re-install the D206-667-101/-201/-103/-203 or D412-667-105 crosstube per section 32.2 of ICA-D206-667.

For customers who would like to upgrade their D206-667-101/-201/-103/-203 or D412-667-105 crosstubes from CHG 002 or earlier to CHG 003, the following kit can be obtained from Dart:

| QTY -011 | QTY -013 | PART NUMBER | DESCRIPTION |
|-------------|-------------|---------------|--|
| X | | DSI 9415-011 | CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-101/-201/-103 OR D407-667-105) |
| | X | DSI 9415-013 | CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-203) |
| 4 | | D3595-075-395 | RUBBER CUSHION |
| | 4 | D3595-075-450 | RUBBER CUSHION |

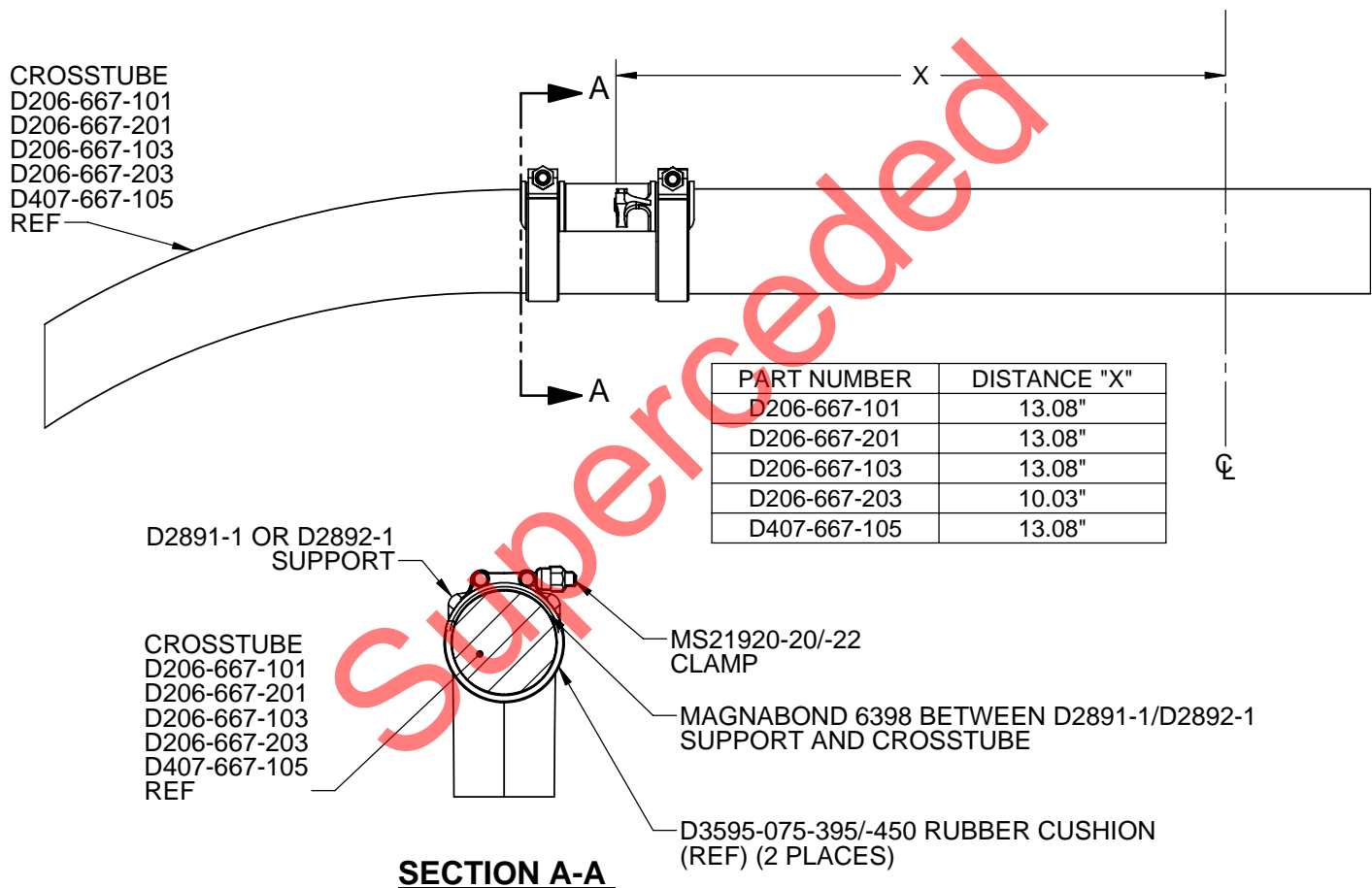





FIGURE 1 - CROSSTUBE SUPPORT

CANADA
DEPARTMENT OF TRANSPORT
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D. SHEPHERD (DE # 02)

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| CHECKED | PH | DRAWING NO. | REV. A |
| MFG. APPR. |  | DSI 9415 | SHEET 2 OF 2 |
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